

CARTON BOTTOM FORMING METHOD AND APPARATUSAbstract of the Disclosure

An apparatus for forming the bottom end wall of a carton from a rectangular carton blank having oppositely disposed scored end panels and oppositely disposed unscored end panels includes a rotating mandrel assembly adapted to receive an open-ended carton blank through an open top end of the carton blank, a heating station, a folding station and a sealing station. The folding station has a pair of oppositely disposed reciprocating break fingers to contact and fold inwardly the scored bottom end panels and biasing means for folding inwardly down the unscored bottom end panels. The folding station is rotatable 90° between two functional orientations, a first orientation wherein the break fingers are aligned in the direction of mandrel movement, and a second orientation in which the break fingers are perpendicular to the direction of mandrel movement.